



PCT/EP200 4 / 0 1 2 8 6 0

02.12.2004

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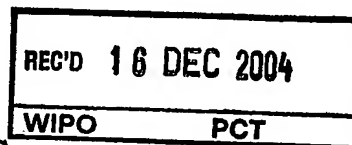
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Aktenzeichen A 1831/2003

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**(Kärnten) und**  
**die Firma Porzellanfabrik Frauenthal GmbH**  
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**(Steiermark),**

am **13. November 2003** eine Patentanmeldung betreffend

**"Abgaskatalysatorzusammensetzung",**

überreicht haben und dass die beigeheftete Beschreibung samt Zeichnungen mit der ursprünglichen, zugleich mit dieser Patentanmeldung überreichten Beschreibung samt Zeichnungen übereinstimmt.

Österreichisches Patentamt  
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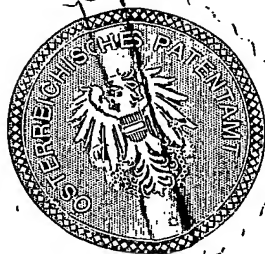
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11831/2003

(51) Int. Cl. : B01D 53/07

CT 5953

AT PATENTSCHRIFT

(11) Nr.

Urtext

(Bei der Anmeldung sind nur die eingerahmten Felder auszufüllen - bitte fett umrandete Felder unbedingt ausfüllen!)

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(54) Titel:  
**Abgaskatalysatorzusammensetzung**

(61) Zusatz zu Patent Nr.

(66) Umwandlung von **GM** /

(62) gesonderte Anmeldung aus (Teilung): **A** /

(30) Priorität(en):

(72) Erfinder:

(22) (21) Anmeldetag, Aktenzeichen:

**13. Nov. 2003**

, **A**

/

(60) Abhängigkeit:

(42) Beginn der Patentdauer:

Längste mögliche Dauer:

(45) Ausgabetag:

(56) Entgegenhaltungen, die für die Beurteilung der Patentierbarkeit in Betracht gezogen wurden:

## Exhaust Gas Catalyst Composition

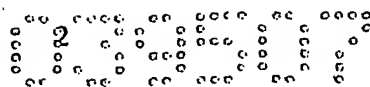
The invention relates to an exhaust gas catalyst composition, in the following "catalyst composition", and a process for its preparation.

The reduction of nitrogen oxide emissions represents one of the greatest challenges in environmental protection. Several approaches have been followed to reduce  $\text{NO}_x$  emissions for both mobile and stationary applications including combustion modification methods and denitrification of flue gases. The former, although  $\text{NO}_x$  removal efficiency varies with the technology applied, cannot achieve more than 50-60% of removal efficiency. After-treatment of flue gases can achieve substantially larger efficiencies especially when a catalytic method is employed. Several type of catalysts have been tested which are active under different environments and conditions. The use of a large number of catalysts to eliminate NO is associated with different reaction pathways that can be divided as follows (1):

1. The selective catalytic reduction of NO with ammonia (herein after referred to as SCR), for stationary applications like power stations and chemical industrial plants.
2. The catalytic reduction of NO in the presence of CO, typical of automotive pollution control.
3. The catalytic reduction of NO in the presence of hydrocarbons, a method not in use commercially but potentially interesting for automotive and industrial pollution control.
4. The direct elimination of NO through decomposition for which a durable and stable catalysts has not yet been developed.
5. The sorbing of NO or  $\text{NO}_x$ -trap catalysts.

Among these methods the most widely employed technology for stationary applications is SCR (2-4). It was introduced in the late 1970s for the control of  $\text{NO}_x$  emissions in stack gases for thermal power plants and other industrial facilities. SCR plants are currently operating in USA, Japan, Europe and Far East for a total capacity of the order of 100000 t/day. The SCR is

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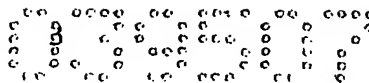


The technology is operated commercially over metal-oxide SCR catalysts made of a homogeneous mixture of  $\text{TiO}_2$  (80-90 wt.-%),  $\text{WO}_3$  (6-10 wt.-%) and  $\text{V}_2\text{O}_5$  (1-3 wt.-%) which may contain some  $\text{SiO}_2$  (0-10 wt.-%) in the formulation. Titania is used as a high surface area carrier to support the active component  $\text{V}_2\text{O}_5$  which is responsible for the activity of catalysts for  $\text{NO}_x$  reduction. It is also responsible for the oxidation of  $\text{SO}_2$  to  $\text{SO}_3$  when  $\text{SO}_2$  containing gases are delivered to the catalyst. Therefore, for high-sulfur content off-gases, its amount is kept low (below 1 wt.-%).  $\text{WO}_3$  (sometime also  $\text{MoO}_3$ ) is employed as a chemical/structural promoter to enlarge the temperature window of application. Silica is often used to improve the catalyst strength and stability. Commercial catalysts are employed as honeycomb monoliths due to several advantages over a packed bed arrangement: lower pressure drop, higher attrition resistance, less plugging by fly ash.

GB 1 495 396 describes a catalyst composition containing as active ingredients oxides from titanium, at least one of molybdenum, tungsten, iron, vanadium, nickel, cobalt, copper, chromium and uranium, and as optional component(s) tin and/or at least one of silver, beryllium, magnesium, zinc, boron, aluminium, yttrium, rare earth metal, silicon, niobium, antimony, bismuth, manganese, thorium and zirconium, which oxides are present as an intimate mixture.

EP 1 145 762 A1 describes a process for the preparation of a vanadia SCR-catalyst supported on titania. The process is characterized in that the catalyst is prepared by dispersing titania in an ammonium metavanadate solution, adjusting the pH of the solution to a value of 7.0-7.1, stirring the resulting suspension for a time for complete adsorption of the vanadium compound on titania, filtering the suspension and drying and calcining the resulting catalyst compound.

In spite of the fact that SCR technology is used worldwide there are still opportunities to improve catalytic performance especially in relation to the following issues: (i) to improve catalyst design in order to obtain at the same time a higher activity in  $\text{NO}_x$  removal and a lower activity in  $\text{SO}_2$  oxidation; (ii) to limit ammonia slip and to improve the behaviour of the system under dynamic conditions; (iii) to extend the present applicable temperature range of SCR catalysts towards higher temperature up to  $600^\circ\text{C}$  and to avoid deactivation which occurs at present catalysts when treated at high temperatures. It is in fact known that the activity of a  $\text{V}_2\text{O}_5/\text{TiO}_2/\text{SiO}_2$  catalyst increases markedly with a rise in calcinations



temperature up to 600-650°C and then rapidly decreases. This is mainly due to phase transformation of  $\text{TiO}_2$  (anatase) into  $\text{TiO}_2$  (rutile) and consequent loss of BET surface area which changes in the chemical state of surface vanadium species. Solving these issues will pave the road for use of SCR also in mobile applications; the process using urea as reducing agent is in fact investigated intensively for use in diesel or gasoline lean-burn engines (5-6). The challenges for automotive applications are high SCR activity and improved thermal stability of vanadia-tungsta-titania catalysts in the temperature range 423-1000K. Such extreme operating temperatures (compared to "classic" SCR applications where temperature range of the order of 573-773K are often encountered) are certainly of short duration and may occur at very high power output (low rpm and high load).

The present invention is aimed to solve the problem related to improvement of thermal stability at higher temperatures where state of the art V/Ti/W/Si and V/Ti/W catalysts still suffer strong deactivation.

The catalyst composition according to the invention is represented by the general formula



wherein

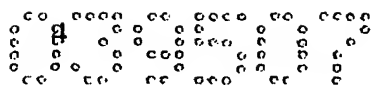
RE is at least one of the group of rare earth metals Y, Ce, Pr, Nd, Sm, Gd, Tb, Dy, Er and Yb in an amount of up to 6.0 wt.-%;

V is vanadium in an amount of 0.2-2.5 wt.-%;

O is oxygen in an amount of up to 3.5 wt.-%; and

S is a support containing  $\text{TiO}_2$  in an amount of at least 70 wt.-%, with the rest being at least one of  $\text{WO}_3$  and  $\text{MoO}_3$ , and optionally  $\text{SiO}_2$ .

The invention is based on the observation that introduction of a rare earth metal (RE) into V/Ti/W/Si and V/Ti/W catalysts strongly improves activity even after aging at temperatures of 750°C for several hours when the activity of state of the art catalysts drops to a significant extent.



In a preferred embodiment RE is at least one of the group of Pr, Sm, Gd, Tb, Dy and Er, and particularly one of the group of Sm, Gd, Tb, Dy and Er, and more preferred at least one of Er and Tb.

Also preferred is that the support S of the catalyst composition contains  $\text{SiO}_2$  in an amount of 4-12 wt.-%, particularly in an amount of 5-10 wt.-%.

The invention is also directed to a process for the preparation of a catalyst composition, characterized in that a solid support containing  $\text{TiO}_2$  in an amount of at least 70 wt.-%, at least one of  $\text{WO}_3$  and  $\text{MoO}_3$  in an amount of 5-20 wt.-%, and optionally  $\text{SiO}_2$  in an amount of up to 15 wt.-%; is contacted with an aqueous solution of a salt of at least one rare earth metal selected from the group of Y, Ce, Pr, Nd, Sm, Gd, Tb, Dy, Er and Yb to give a slurry which is brought to dryness and calcined. By bringing the solid support in contact with the solution of the rare earth salt, adsorption on the support takes place.

In a more preferred embodiment the rare earth metal is at least one of the group of Pr, Sm, Gd, Tb, Dy and Er, and particularly one of the group of Sm, Gd, Tb, Dy and Er, and more preferred at least one of Er and Tb.

The aqueous solution of the at least one rare earth metal may also contain a vanadium salt.

The invention is also directed to a catalyst composition which is obtainable according to the inventive process mentioned above.

The invention is also directed to a catalyst composition which is obtainable according to the inventive process containing  
said rare earth metal in an amount of up to 6.0 wt.-%;  
optionally vanadium in an amount of up to 2.5 wt.-%;  
oxygen in an amount of up to 3.5 wt.-%;  
 $\text{TiO}_2$  in an amount of at least 65 wt.-%,  
at least one of  $\text{WO}_3$  and  $\text{MoO}_3$  in an amount of up to 20 wt.-%,  
and optionally  $\text{SiO}_2$  in an amount of up to 15 wt.-%.

In the following preferred embodiments of the invention are described in more detail.

The catalysts according to the invention were obtained starting from two support materials of composition 81%TiO<sub>2</sub>-9%WO<sub>3</sub>-10%SiO<sub>2</sub> (Ti/W/Si) and 90% TiO<sub>2</sub>-10%WO<sub>3</sub> (Ti/W). To this support, a combination of V and RE elements were added to provide a NO<sub>x</sub> reduction catalysts represented by the formula REVO/Ti-W-Si with RE= Y, Ce, Pr, Nd, Sm, Gd, Tb, Dy, Er and Yb. The content of the active phase was in the range up to 5.1 wt.-% RE element, 0.4-2.1 wt.-% Vanadium and up to 2.7 wt.-% Oxygen, corresponding to a REVO loading in the range of 2.5-8.5 wt.-%

1. Preparation of a catalyst according to the invention containing 5.0 wt.-% Er and 1.5 wt.-% V on a Ti-W-Si support

#### 1.1. Preparation of the Ti-W-Si support

Preparation of the support was carried out according to (7): 92.68g of titanium tetrachloride (TiCl<sub>4</sub>) was added dropwise to 1 liter of water under ice cooling with stirring. Then 16.06g of Lithosol 1530 KD (a tradename for a product of Zschimmer & Schwarz Chemische Fabriken, containing 30% of SiO<sub>2</sub> in the sol state) were added. While thoroughly stirring the mixture at about 30°C, ammonia water was gradually added. When the pH of the mixture reached 7, the addition was stopped. The mixture was aged by allowing it to stand for 2 hours. The resulting TiO<sub>2</sub>-SiO<sub>2</sub> gel was filtered, washed with water, dried at 120°C for 10 hours and further washed with water, then calcined at 500°C for 3 hours. The resulting TiO<sub>2</sub>-SiO<sub>2</sub> powder contained 86 mole% of titanium and 14 mole% of silicon as SiO<sub>2</sub>. The resulting powder was designated as (Ti/Si).

A solution of 8.16g of ammonium paratungstate [(NH<sub>4</sub>)<sub>10</sub>W<sub>12</sub>O<sub>41</sub>·5H<sub>2</sub>O] in 500 ml of distilled water was added to 73.4g of (Ti/Si). They were thoroughly mixed with stirring, concentrated, dried and calcined at 500°C for 6 hours. The resulting support had a weight% of 1.16g

An aliquot of 69.7 mg of ammonium metavanadate was dissolved in 10 ml of 1N oxalic acid. The solution was heated in order to obtain the blue complex  $(\text{NH}_4)_2[\text{VO}(\text{C}_2\text{O}_4)_2]$  and then 2478.2 mg of erbium acetate solution (4.6% of Er) were added under mixing. Moreover, some drops of  $\text{HNO}_3$  were added in order to avoid the precipitation of the erbium oxalate. Then, the support (1831.8 mg of mixed oxide containing 81% $\text{TiO}_2$ -9% $\text{WO}_3$ -10% $\text{SiO}_2$ ) was added. This slurry was brought to dryness under continuous stirring at 80-100°C. Finally, the solid was dried at 120°C overnight and calcined at 650°C for 2 hours, pressed into pellet, crushed and sieved in the range 355-425  $\mu\text{m}$ . This will be referred as fresh sample.

Aging of samples was carried out in a tubular furnace at a temperature of 750°C for 10 hours under air.

## 2. Preparation of a state of the art catalyst 1.7%V/Ti/W (8)

### 2.1. Preparation of the Ti-W support

The preparation of the support was carried out according to (9) : 87g of titanium tetrachloride ( $\text{TiCl}_4$ ) were poured into 300 ml of ice water and the solution was neutralized with 3N ammonia water. The resulting precipitate was separated by filtration, and thoroughly washed with distilled water. A solution of 4.58g of ammonium paratungstate  $[(\text{NH}_4)_{10}\text{W}_{12}\text{O}_{41} \cdot 5\text{H}_2\text{O}]$  in 325 ml of distilled water was thoroughly mixed with the resulting cake. The resulting slurry was dried, and calcined at 500°C for 6 hours in a muffle furnace. The resulting support had a weight% ratio  $\text{TiO}_2:\text{WO}_3$  of 90:10.

### 2.2. Preparation of the catalyst 1.7%V/Ti/W

An aliquot of 77.2 mg of ammonium metavanadate was dissolved in 10 ml of 1N oxalic acid. The solution was heated in order to obtain the blue complex  $(\text{NH}_4)_2[\text{VO}(\text{C}_2\text{O}_4)_2]$ . Then, the support (1940 mg of mixed oxide containing 90% $\text{TiO}_2$ -10% $\text{WO}_3$ ) was added. This slurry was brought to dryness under continuous stirring at 80-100°C. Finally, the solid was dried at 120°C overnight and calcined at 650°C for 2 hours, pressed into pellet, crushed and sieved in the range 355-425  $\mu\text{m}$ .



The specific surface areas of oxide powders were measured by the BET method using N<sub>2</sub> adsorption/desorption at 77K with a Sorptomatic 1990 instrument (Carlo Erba).

### 3. Catalyst Testing

Catalyst testing was carried out in the apparatus described in Figure 1. The gas feed consisted of NH<sub>3</sub>/N<sub>2</sub>, NO/N<sub>2</sub>, O<sub>2</sub>, N<sub>2</sub>. Mass flow meters were used to measure and control the single gaseous stream while an injection pump was used to introduce water. The feed stream was preheated and premixed and ammonia was added to the gaseous mixture immediately before entering the reactor to avoid side reactions. A tubular quartz reactor was employed inserted in a furnace. Temperature was controlled by a thermocouple inserted in the catalyst bed. The gas exiting the reactor was scrubbed with an aqueous solution of phosphoric acid to trap unconverted ammonia and then cooled to condense water vapor. Activity of the catalysts were measured under stationary conditions in a temperature range of 250°C to 450°C. Unless otherwise reported the standard gas composition and reaction conditions given in Table 1 were used. Conditions were selected in order to have a conversion not exceeding ca. 90% with reference catalyst. Gas composition analysis was carried out with an FTIR spectrometer equipped with a gas cell.

Table 2 shows NO<sub>x</sub> removal efficiency in the temperature range 250-450°C for catalysts containing 0.4-2.1 wt.% V and 1.4-5.1 wt.% RE on Ti/W/Si support. For comparison the activity of the state of the art reference catalyst based on 1.7 wt.% V/Ti/W are also reported.

The NO<sub>x</sub> reduction activity of all the catalysts examined in the present study increased with increasing reaction temperature up to ca. 300-350°C where a maximum NO<sub>x</sub> reduction activity was observed. At this point the activity began to decrease due to ammonia oxidation reaction to NO<sub>x</sub> which is prevailing over its reaction to N<sub>2</sub>. A strong effect is also shown with calcination temperatures. Particularly for the state of the art catalyst calcined at temperature above 650°C strong deactivation is observed with conversion dropping at values between 5-

Er and Tb containing catalysts where a substantial increase of conversion is observed after ageing in all temperature range examined.

The overall picture detailing activity drop/improvement after aging is shown in Figure 2, which also highlights a dependence of activity on position of the element in the periodic table.

Table 2 shows also the NO<sub>x</sub> removal efficiency against RE and V loading. The loading amount was controlled by varying the amount of ammonium vanadate and rare earth acetate solutions in the impregnation. The preparation of a 0.4 wt.% V and 1.5 wt.% Er on Ti/W/Si is reported below.

The support was prepared as already described. The supported catalysts were prepared according to the following procedure: 19 mg of ammonium metavanadate were dissolved in 10 ml of oxalic acid 1N. The solution was heated in order to obtain the blue complex (NH<sub>4</sub>)<sub>2</sub>[VO(C<sub>2</sub>O<sub>4</sub>)<sub>2</sub>] and then 619.6 mg of erbium acetate solution (4.6% of Er) were added. Moreover, some drops of HNO<sub>3</sub> were added in order to avoid the precipitation of the erbium oxalate. Then, the support (1831.8 mg of Ti/W/Si) was added. This slurry was brought to dryness under continuous stirring at 80-100°C. Finally, the solid was dried at 120°C overnight and calcined at 650°C for 2 hours, pressed into pellet, crushed and sieved in the range 355-425 µm].

As listed in table 2 (examples 8-10, 12-13) loading does not affect strongly activity after aging. For all the sample investigated an unusual promotion of activity is observed after aging at 750°C. Catalysts in the fresh state are less active at the lowest loading, (especially at the lowest temperatures) consistently with the presence of a lower amount of active phase containing vanadium. Maximum of activity is observed always at 320°C.

Surface area analysis is reported in Table 4 and 5. With all the catalysts examined aging procedure causes a drop in surface area which is proportional to the amount of RE and V deposited. This would suggest that aging induce an interaction between the active phase containing rare earths and the support.

X-ray diffraction analysis of the supports showed that TiO<sub>2</sub> (anatase) is the only phase detected after aging at 750°C under air for 10h, indicating that transformation to rutile does

not occur. The presence of silica has no effect on X-ray diffraction profile under these conditions. Aging under more severe conditions (850°C, 10h) induces a modification of diffraction profile of both supports. Segregation of crystalline  $\text{WO}_3$  is observed in both samples while for supports not containing silica,  $\text{TiO}_2$  in the form of rutile is clearly evidenced. The introduction of  $\text{SiO}_2$  strongly stabilizes anatase against its transformation to rutile. The introduction of vanadium modifies this picture by accelerating segregation of  $\text{WO}_3$ -containing phases and transformation of anatase to rutile.

Figure 3 and 4 show respectively X-ray diffraction profiles of fresh and aged  $\text{V}_2\text{O}_5/\text{WT}$  and  $\text{V}_2\text{O}_5/\text{WTS}$ . Peaks characteristic of  $\text{V}_2\text{O}_5$  are not seen in both supports indicating that  $\text{V}_2\text{O}_5$  is either amorphous when supported on  $\text{TiO}_2$  or that the particle size is below the detection limits of X-ray technique. This is in agreement with the fact that crystalline  $\text{V}_2\text{O}_5$  on  $\text{TiO}_2$  is observed only at higher loading (10). In the presence of  $\text{V}_2\text{O}_5$  the anatase to rutile phase transformation is initiated at lower temperature, as a consequence for WT support after calcinations at 750 for 10h approx 50% of  $\text{TiO}_2$  is in the form of rutile. The presence of  $\text{V}_2\text{O}_5$  also accelerates segregation of crystalline  $\text{WO}_3$  phase, in accordance with previous observations (10-11).

A more accurate analysis of X-ray diffraction profiles indicate that modification of  $\text{WO}_3$  by introduction of foreign cations into the oxide lattice could be responsible of small differences in the peak positions. Formation of mixed  $\text{Ti}_x\text{W}_y\text{O}_3$  or  $\text{M}_x\text{W}_y\text{O}_3$  (with M being an impurity present in the support) could be a possibility although no evidence can be found from existing XRD patterns. The presence of residual Ca from commercial additives was responsible of formation of  $\text{CaWO}_4$  in structured catalysts of similar composition treated at comparable temperatures (11). Reaction of supported vanadia with  $\text{TiO}_2$  to yield  $\text{V}_x\text{Ti}_{1-x}\text{O}_2$  in which vanadium is incorporated into the titania support in the form of rutile has been previously observed. In our case, lattice parameters of  $\text{TiO}_2$  (rutile) stabilized in the presence and in the absence of vanadia are coincident, indicating that formation of TiVO solid solution does not occur.  $\text{WO}_3$  containing support shows a similar shorter anatase to rutile transformation.

elements investigated. Calcinations at 750°C clearly evidence formation of crystalline  $\text{REVO}_4$  for all elements with the exception of La. Interestingly, the presence of lanthanides seems to positively influence the degree of rutilization of the support and the process of segregation/formation of  $\text{WO}_3$ . For silica containing support rutile is seen only at calcinations temperatures above 750°C and the appearance of crystalline  $\text{WO}_3$  is also retarded (this is true except for Tb, Ce and Pr-containing catalysts where the formation of  $\text{WO}_3$  is not affected if compared with  $\text{V}_2\text{O}_5$ -only samples). In the absence of silica, segregation of  $\text{WO}_3$  and transformation to rutile occur already at temperature of 750°C, although the presence of RE slow down their formation. Figure 5 shows the effect of aging treatment at temperatures in the range 650-850°C for Tb-V-O/WTS.

*Table 1: Reaction conditions and gas composition.*

Catalyst weight	100,0 mg
Particle size	350-425 $\mu\text{m}$
Total flow	0,3 l/min
Temperature	250-450°C
NO conc.	200 ppm
NH3 conc.	240 ppm
O2 conc.	20000 ppm
H2O conc.	10%
N2 conc.	balance

*Table2: Activity of fresh and aged catalysts containing RE and V on  $\text{TiO}_2:\text{WO}_3:\text{SiO}_2$  (81:9:10) matrix.*

Example Nr	RE	RE [%]	V [%]	NO conversion in %					
				250°C fresh	250°C aged	320°C fresh	320°C aged	450°C fresh	450°C aged
1	Y	3,7	2,1	49	25	70	49	55	29
2	La	4,6	1,7	31	0	51	0	38	3
3	Ce	4,6	1,7	67	20	86	31	46	21

4	Pr	4,6	1,7	51	25	74	37	35	16
5	Nd	4,7	1,7	40	20	62	30	43	11
6	Sm	4,8	1,6	40	55	64	61	43	29
7	Gd	4,9	1,6	50	48	61	68	47	60
8	Tb	1,4	0,5	22	68	53	90	50	65
9	Tb	2,8	0,9	40	63	68	81	51	45
10	Tb	4,9	1,6	32	52	49	80	40	49
11	Dy	4,9	1,5	48	52	64	75	50	48
12	Er	1,5	0,4	24	46	52	71	49	47
13	Er	5	1,5	40	47	65	80	54	53
14	Yb	5,1	1,5	45	47	72	49	48	25
(Reference)	-	-	1,7	85	5	91	17	17	7

Table 3: Activity of fresh and aged catalysts containing RE and V on TiO<sub>2</sub>:WO<sub>3</sub> (90:10) matrix.

Example Nr	RE	RE [%]	V [%]	NO conversion in %					
				250°C	250°C	320°C	320°C	450°C	450°C
				fresh	aged	fresh	aged	fresh	aged
15	Er	5	1.5	58	17	81	46	46	9
16	Tb	4.9	1.6	62	25	88	48	48	29
17	Pr	4.6	1.6	64	23	80	40	40	17
18	Ce	4.6	1.7	83	3	94	27	27	6
(Reference)	-	-	1,7	85	5	91	13	36	10

2	La	4,6	1,7	68	22
3	Ce	4,6	1,7	62	17
4	Pr	4,6	1,7	60	28
5	Nd	4,7	1,7	66	24
6	Sm	4,8	1,6	64	28
7	Gd	4,9	1,6	64	28
8	Tb	1,4	0,5	80	56
9	Tb	2,8	0,9	76	45
10	Tb	4,9	1,6	67	35
11	Dy	4,9	1,5	68	19
12	Er	1,5	0,4	-	-
13	Er	5,0	1,5	68	33
14	Yb	5,1	1,5	70	11

Table 5: Surface area of fresh and aged V containing catalysts on TiO<sub>2</sub>:WO<sub>3</sub>:SiO<sub>2</sub> (81:9:10) and TiO<sub>2</sub>/WO<sub>3</sub> (90:10) matrix.

Sample	Surface area	
	Fresh	Aged
V <sub>2</sub> O <sub>5</sub> on Ti/W/Si (81:9:10)	65	8
Ti/W/Si (81:9:10)	88	70
V <sub>2</sub> O <sub>5</sub> on Ti/W/ (90:10)	24	6
Ti/W (90:10)	59	29

Table 6: Identification of phases with XRD on samples (4.6÷5% RE loading) calcined at different temperatures.

dopant	support	Aging at 650°C			Aging at 750°C		
		REVO	Rutile	WO <sub>3</sub>	REVO	Rutile	WO <sub>3</sub>
		4			4		
Y	WTS	v.weak	none	none	yes	none	None
La	WTS	none	none	none	weak	none	v.weak
Ce	WTS	v.weak	none	none	yes	none	Yes

Pr	WTS	v.weak	none	v.weak	yes	none	Yes
Nd	WTS	v.weak	none	none	yes	none	v.weak
Sm	WTS	none	none	none	yes	none	v.weak
Gd	WTS	v.weak	none	none	yes	none	v.weak
Tb	WTS	none	none	none	yes	v.weak	Yes
Dy	WTS	v.weak	none	none	yes	none	Weak
Er	WTS	v.weak	none	none	yes	none	None
Yb	WTS	v.weak	none	none	yes	none	Weak
Ce	WT	none	none	none	yes	yes	yes
Pr	WT	none	none	none	yes	yes	yes
Tb	WT	none	none	none	yes	yes	yes
Er	WT	none	none	none	yes	yes	yes

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## Claims

1. Catalyst composition represented by the general formula



wherein

RE is at least one of the group of rare earth metals Y, Ce, Pr, Nd, Sm, Gd, Tb, Dy, Er and Yb in an amount of up to 6.0 wt.-%;

V is vanadium in an amount of 0.2-2.5 wt.-%;

O is oxygen in an amount of up to 3.5 wt.-%; and

S is a support containing  $\text{TiO}_2$  in an amount of at least 70 wt.-%, with the rest being at least one of  $\text{WO}_3$  and  $\text{MoO}_3$ , and optionally  $\text{SiO}_2$ .

2. Catalyst composition according to claim 1, characterized in that RE is at least one of the group of Pr, Sm, Gd, Tb, Dy and Er and particularly one of the group of Sm, Gd, Tb, Dy and Er.

3. Catalyst composition according to claim 2, characterized in that RE is at least one of Er and Tb.

4. Catalyst composition according to any of claims 1-3, characterized in that S contains  $\text{SiO}_2$  in an amount of 4-12 wt.-%, particularly in an amount of 5-10 wt.-%.

5. Process for the preparation of a catalyst composition, characterized in that a solid support containing  $\text{TiO}_2$  in an amount of at least 70 wt.-%, at least one of  $\text{WO}_3$  and  $\text{MoO}_3$  in an amount of 5-20 wt.-%, and optionally  $\text{SiO}_2$  in an amount of up to 15 wt.-%, is contacted with an aqueous solution of a salt of at least one rare earth metal selected from the group of Y,



Ce, Pr, Nd, Sm, Gd, Tb, Dy, Er and Yb to give a slurry which is brought to dryness and calcined.

6. Process according to claim 5, characterized in that the rare earth metal is at least one of the group of Pr, Sm, Gd, Tb, Dy and Er and particularly one of the group of Sm, Gd, Tb, Dy and Er.

7. Process according to claim 6, characterized in that the rare earth metal is at least one of Tb and Er.

8. Process according to one of claims 5 to 7, characterized in that the aqueous solution of the at least one rare earth metal contains also a vanadium salt.

9. Catalyst composition obtainable according to a process of one of the claims 5 to 8.

10. Catalyst composition according to claim 9, containing  
 said rare earth metal in an amount of up to 6.0 wt.-%;  
 optionally vanadium in an amount of up to 2.5 wt.-%;  
 oxygen in an amount of up to 3.5 wt.-%;  
 $\text{TiO}_2$  in an amount of at least 65 wt.-%;  
 at least one of  $\text{WO}_3$  and  $\text{MoO}_3$  in an amount of up to 20 wt.-%,  
 and optionally  $\text{SiO}_2$  in an amount of up to 15 wt.-%.

# Abstract

Catalyst composition represented by the general formula



wherein

RE is at least one of the group of rare earth metals Y, Ce, Pr, Nd, Sm, Gd, Tb, Dy, Er and Yb

in an amount of up to 6.0 wt.-%;

V is vanadium in an amount of 0.2-2.5 wt.-%;

O is oxygen in an amount of up to 3.5 wt.-%; and

S is a support containing  $\text{TiO}_2$  in an amount of at least 70 wt.-%, with the rest being at least one of  $\text{WO}_3$  and  $\text{MoO}_3$ , and optionally  $\text{SiO}_2$ .

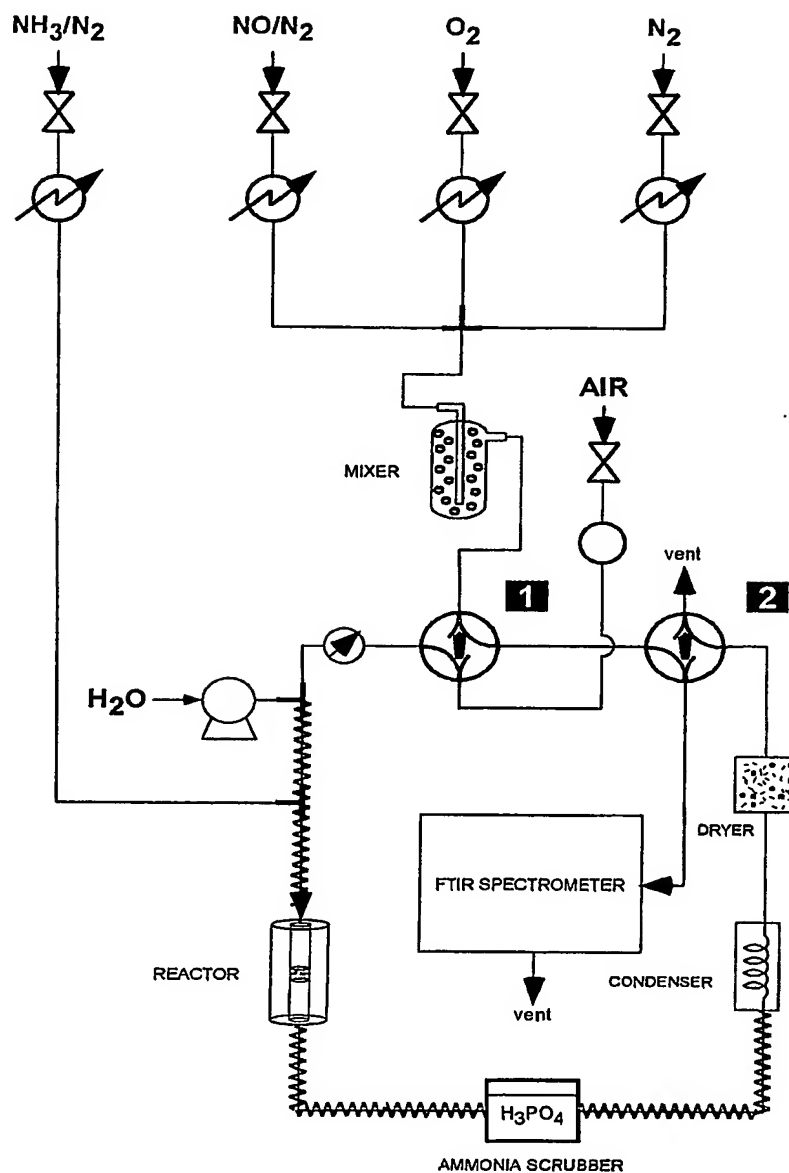
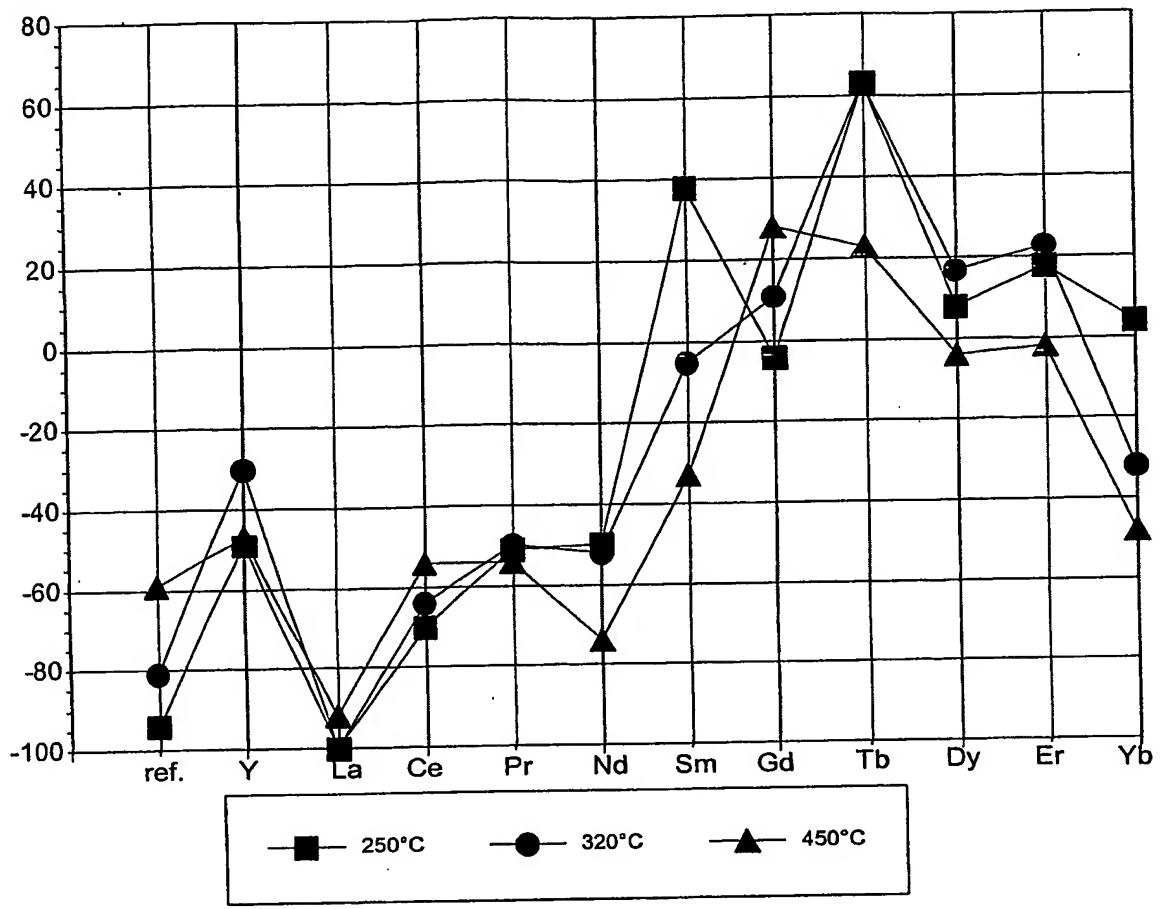


Figure 1: Scheme of the apparatus



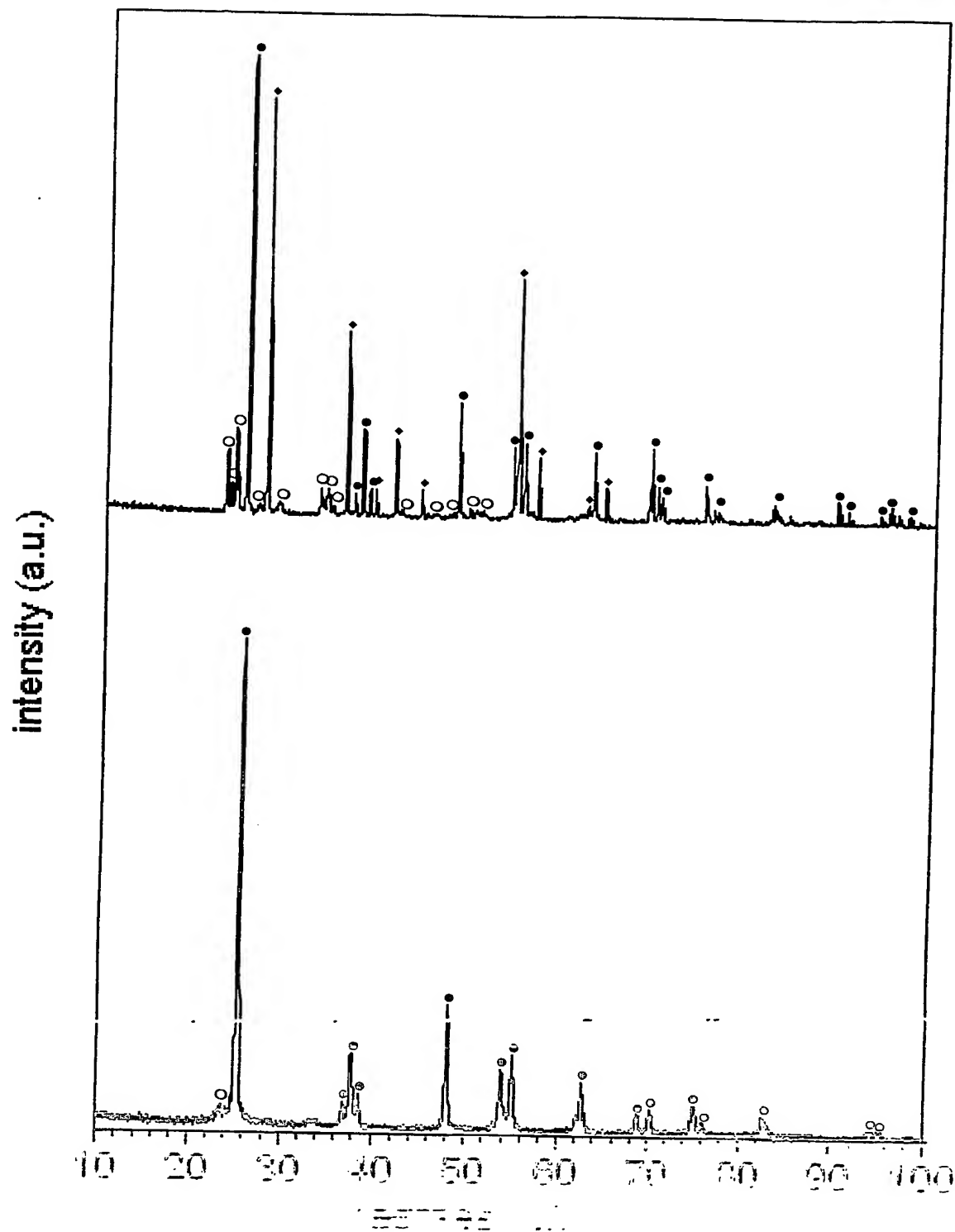
ref.: 3%V<sub>2</sub>O<sub>5</sub>/WO<sub>3</sub>/TiO<sub>2</sub>

Figure 2: Activity drop/increase (%) after aging for various temperatures

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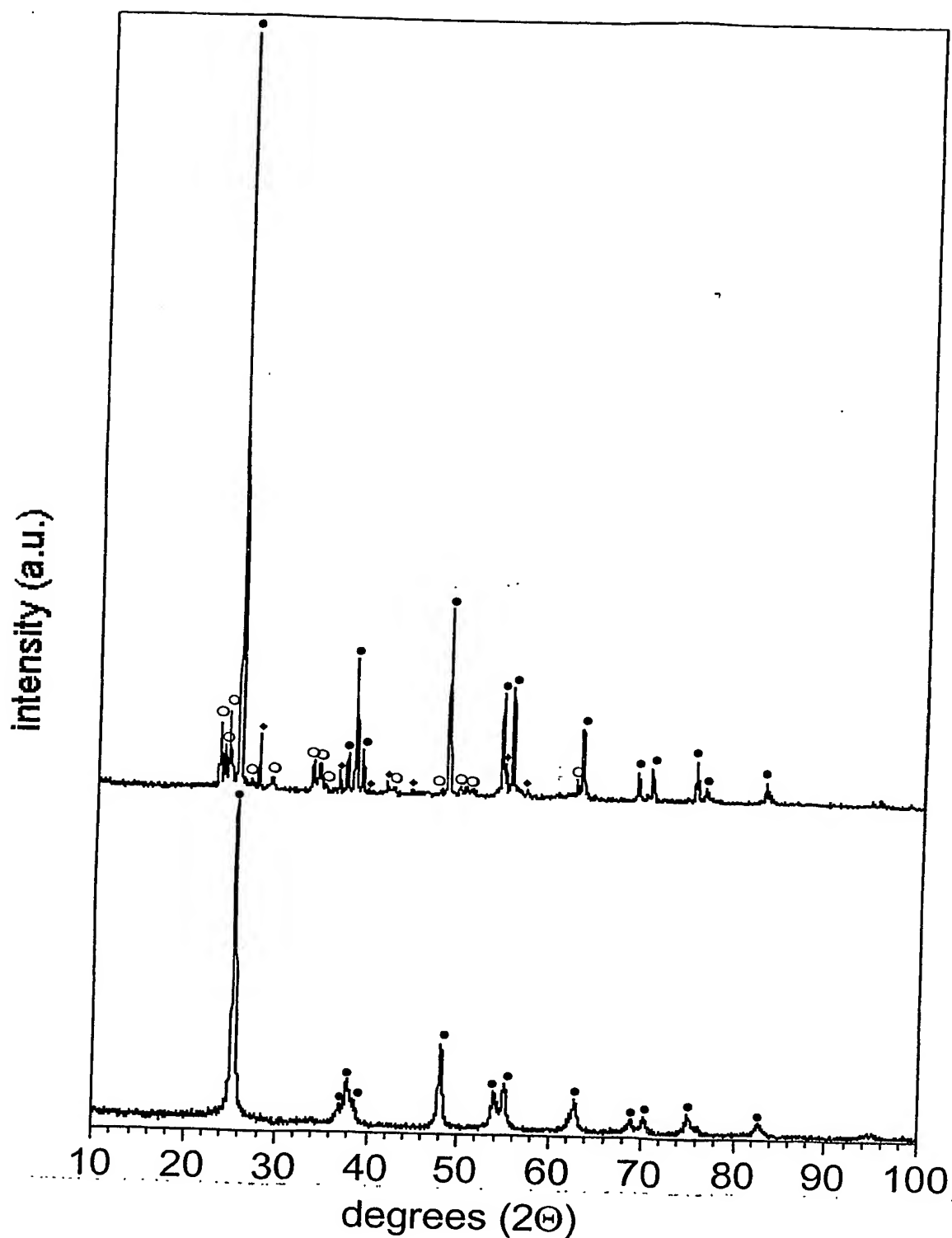
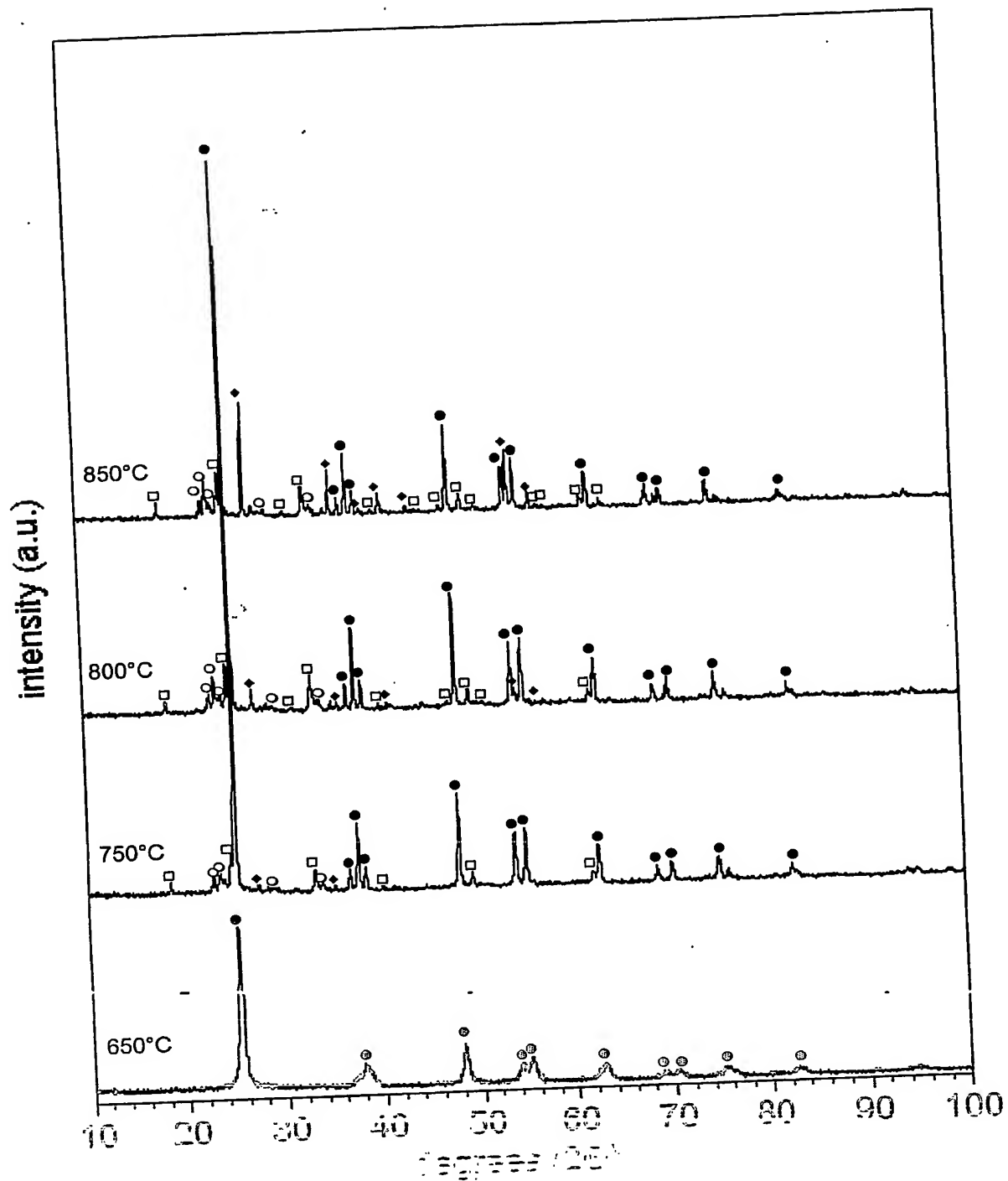


Figure 4: X-ray diffraction profiles of fresh and aged  $V_2O_5$ -WTS; rutile( $\blacklozenge$ ); anatase( $\bullet$ );  $WO_3$ ( $\circ$ ).

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